

Date: Tuesday, 7/17/2007 1:59:23 PM  
User: Kim Johnston

## Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : STEP WELDMENT

Job Number : 33579

Estimate Number : 12576

P.O. Number :

This Issue : 7/17/2007 S.O. No. :

Prsht Rev. : NC

First Issue : 1/1 Type : LARGE FAB ASSY

Previous Run : 32719

Part Number : D3562041

Drawing Number : D3562 UNDER REVIEW

Project Number : N/A

Drawing Revision : AC

Material :

Due Date : 8/3/2007

Qty: 6 U/m Each

Written By :

Checked &amp; Approved By :

Comment : Est Rev:A New Issue 06-11-09 JLM

Additional Product

Job Number

Seq. #: Machine Or Operation:

Description :

10

D2622-120C

Extrusion

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 332858

Check Material for any Dents or Defects

20

D2734

206 Step Endplate

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 C2734 End Cap 333841

30

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cu: D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

3-Weld (1)end cap as per Dwg D3562&amp; QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562





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## Process Sheet

Customer: CU-DAR031 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation: Description:

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

B 32643

9.0

D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

Batch: B 32646

10.0

MS206C3AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 216.0000 Each(s)

Blind Rivet

batch: m 8953

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill: Rivet holes as per dwg D3562.

Touch-up rivet holes with alodine as per dwg d3562

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step





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Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R

Magnabond 6398

Batch:

M104677

07-10-02 1

12.0

QC5

INSPECT WORK TO CURRENT STEP



checked in Helicopter



Comment: INSPECT WORK TO CURRENT STEP

07/10/02

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R

Aluminum Rod

M103794

07-10-02 1

2-Grind end cap welds flush as per Dwg D3562

07-10-02 1

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-02 ①

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/02

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-10-02 ①

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch:

M105694

M-L 07/10/02

①

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/02

18.5 ★ SEE W/D CHG

\* 02L #5 En 07/10/02

PTO

OFFICE OF THE  
SHERIFF  
COUNTY OF ALBANY  
STATE OF NEW YORK

Date: Tuesday, 11/17/2007 1:59:23 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3582041

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

*Per Draft 7/10/02 sel*

20.0

QC21

FINAL INSPECTION/W/O RELEASE



*07.10.02*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



*U 07.10.02*



RELEASED  
07-06-29-~~11~~

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

1.00

45.0°

D2734 END PLATE  
(TYP 2 PLACES)

D3562-041, MAKE FROM EXTRUSION D2622

APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS

D3560-043 ARM WELDMENT (FOR D3562-041, SHOWN) OR D3560-044 ARM WELDMENT (FOR D3562-042, OPPOSITE)

D2808 (REF)

D3560-041 ARM WELDMENT (FOR D3562-041, SHOWN) OR D3560-042 ARM WELDMENT (FOR D3562-042, OPPOSITE)

D2808 SPACER, PRESS FIT AFTER POWDER COAT ON OPPOSITE SIDE (2 PLACES)

REFER TO STEP END DETAIL

TRANSFER DRILL #30 INSTALL MS20600AD4W5 RIVET (32 PLACES), DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING

4.30 71.707 9.20 (REF) 85.15

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

D3562-041 LH STEP ASSEMBLY (SHOWN)  
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

D3562-041 LH STEP ASSEMBLY (SHOWN)  
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

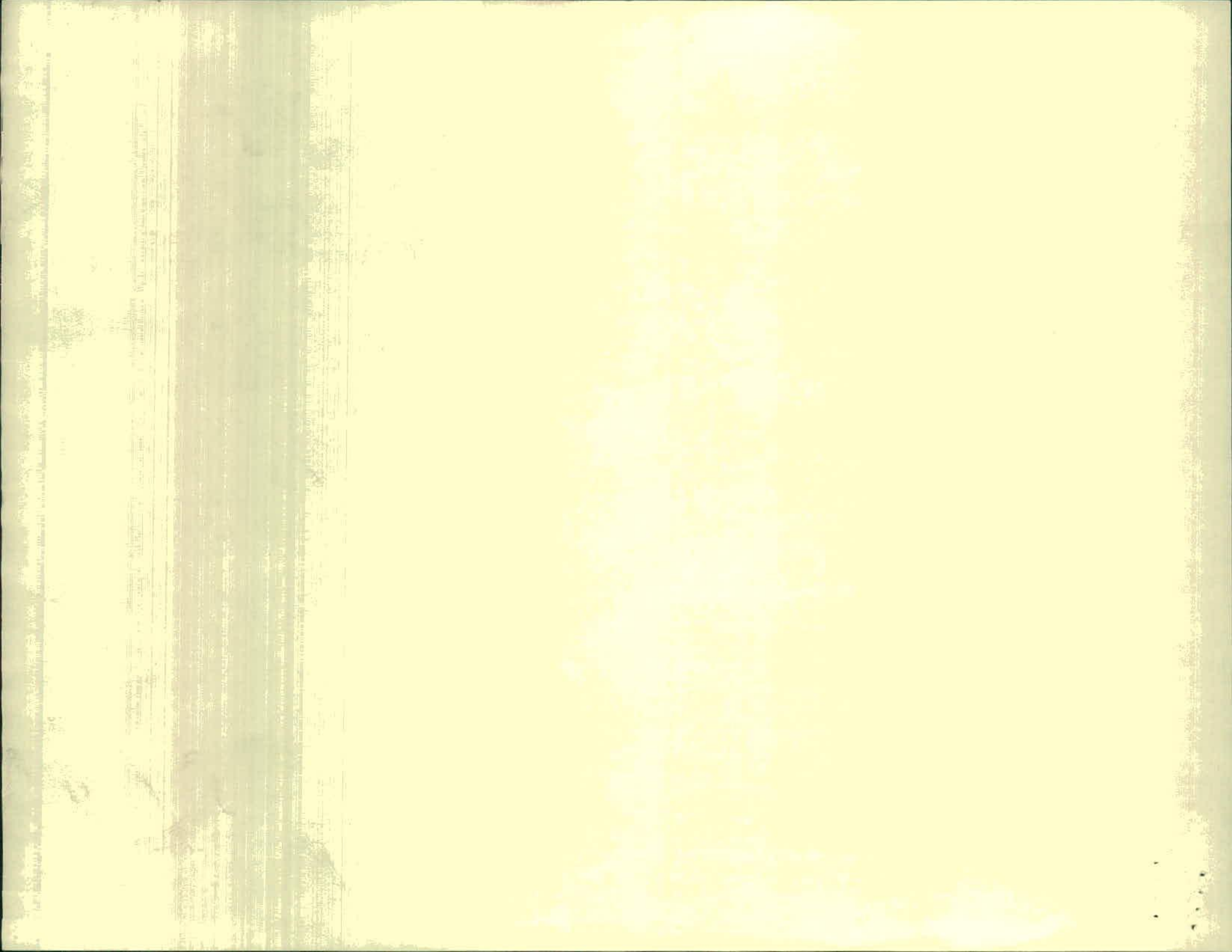
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN		DRAWN BY		DRAWING NO.		REV: C	
q		q		D3562		SHEET 1 OF 1	
CHECKED	<del>11</del>	APPROVED	<del>11</del>			SCALE	
DATE				TITLE		NTS	
07.06.19				STEP ASSEMBLY			
A		06.09.26		NEW ISSUE			
B		07.01.15		ARMS NOW RIVETED TO STEP			
C		07.06.19		NOW MAGBND, ADD D2808, RMV 4 RVTs			

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/10/02	13	ADD 2 D 2808 0 32782 inspect QCS	SA	07/10/02	1			
		for 07/10/08						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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